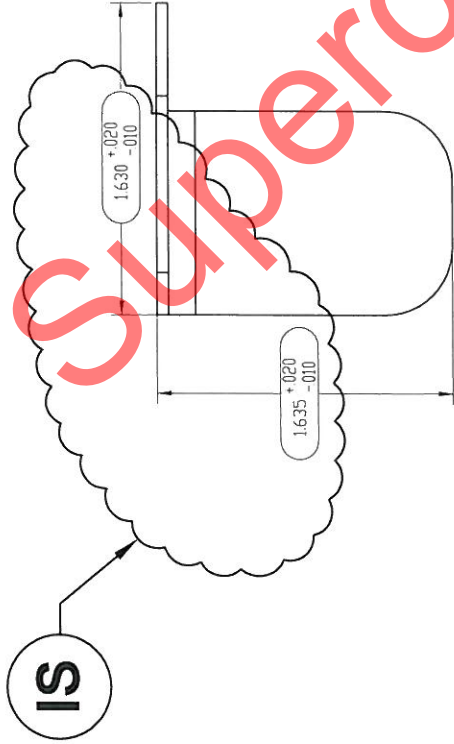
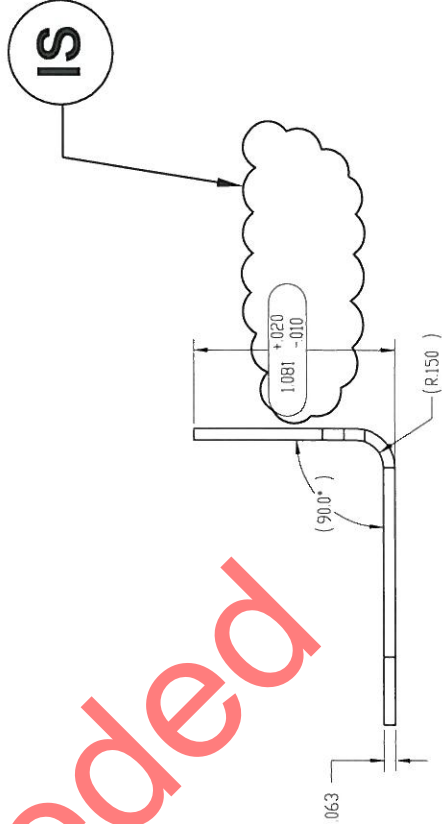


ENGINEERING CHANGE NOTICE NO. 03707		SHEET 1 OF 2	
DWG NO. 647.9000	REV: N/C	DATE: 11/16/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
DWG TITLE: SHEETMETAL			
APPROVED BY: <i>[Signature]</i>	ENGR: <i>[Signature]</i>	MFG: <i>[Signature]</i>	QC: <i>[Signature]</i>
REASON: REVISED TOLERANCES AND REFERENCE DIMENSIONS.		EFF: NEXT ORDER	
TRANSACTION CODES (T/C): A-ADD R-REVISE C-CREATE D-DELETE		ECR: D-12-019	



**SHEET 3, ZONE B1 & B2 IS:**



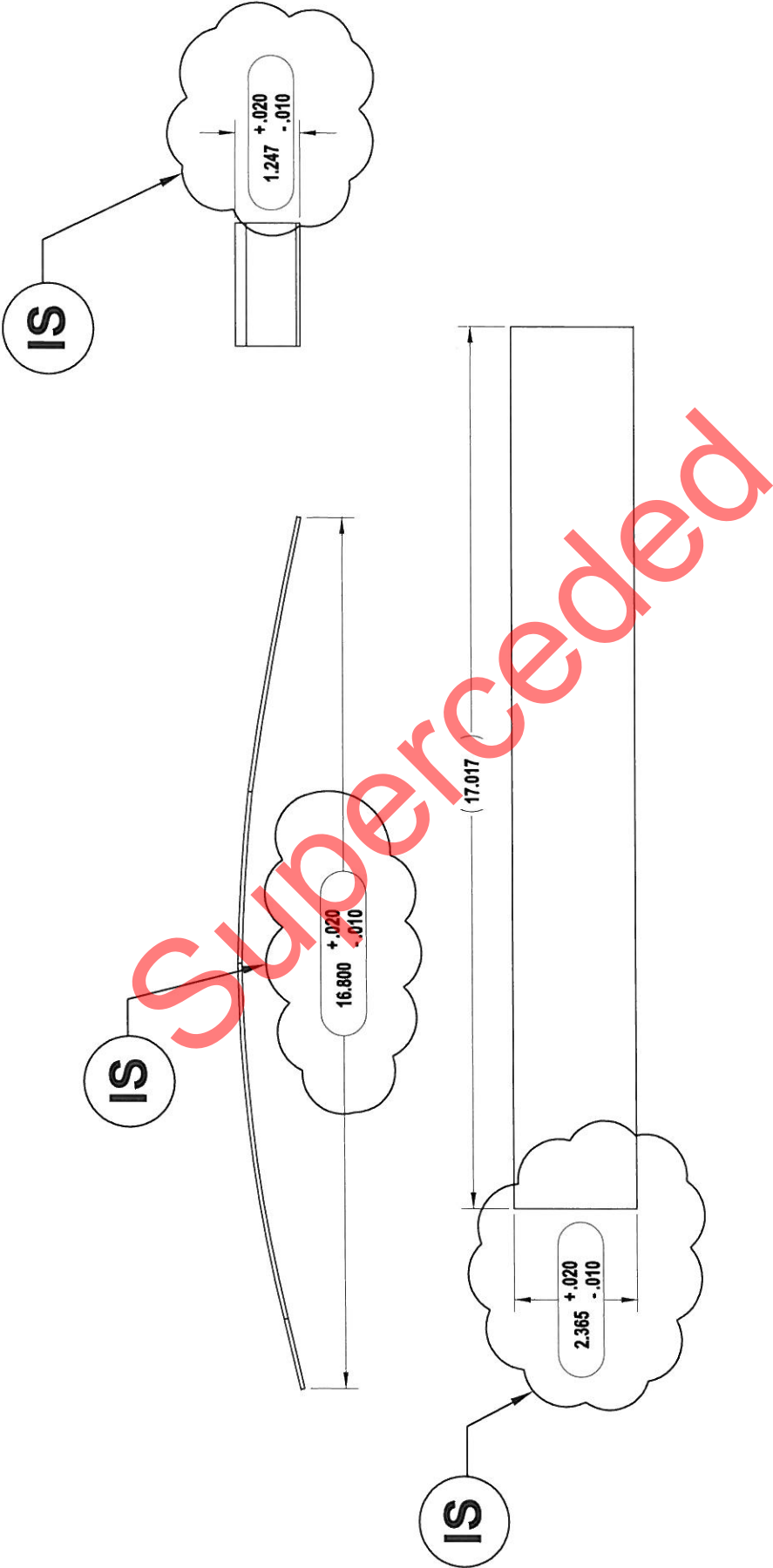
**SHEET 3, ZONE D6 IS:**

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL <input type="checkbox"/> INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

APICAL INDUSTRIES, INC.		ENGINEERING CHANGE ORDER NO. 03707		SHEET 2 OF 2	
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL / SPECIFICATION

**SHEET 6 IS:**

Technical drawing of a curved part with three IS callouts. The first callout points to a dimension of 2.365 (+.020, -.010). The second callout points to a dimension of 16.800 (+.020, -.010). The third callout points to a dimension of 1.247 (+.020, -.010). A large red 'Superceded' watermark is diagonally across the drawing.



**SHEET 6 IS:**

ENGINEERING CHANGE NOTIC		NO. 03266		SHEET 1		OF 2	
DWG NO. 647.9000		REV: N/C		PREPARED BY		A. QUAN	
DATE: 11/15/11		EFFECT ON DWG		INC.		UNINC.	
DWG TITLE: SHEETMETAL							
APPROVED BY:		ENGR		MFG		EFF:	
REASON: REVISED 647.9014 MATERIAL, REVISED DIMENSIONS OF P/N 647.9012		OF		CURRENT ORDER AND STOCK			
TRANSACTION CODES (TC)		A-ADD		C-CREATE		R-REVISE	
D-DELETE							

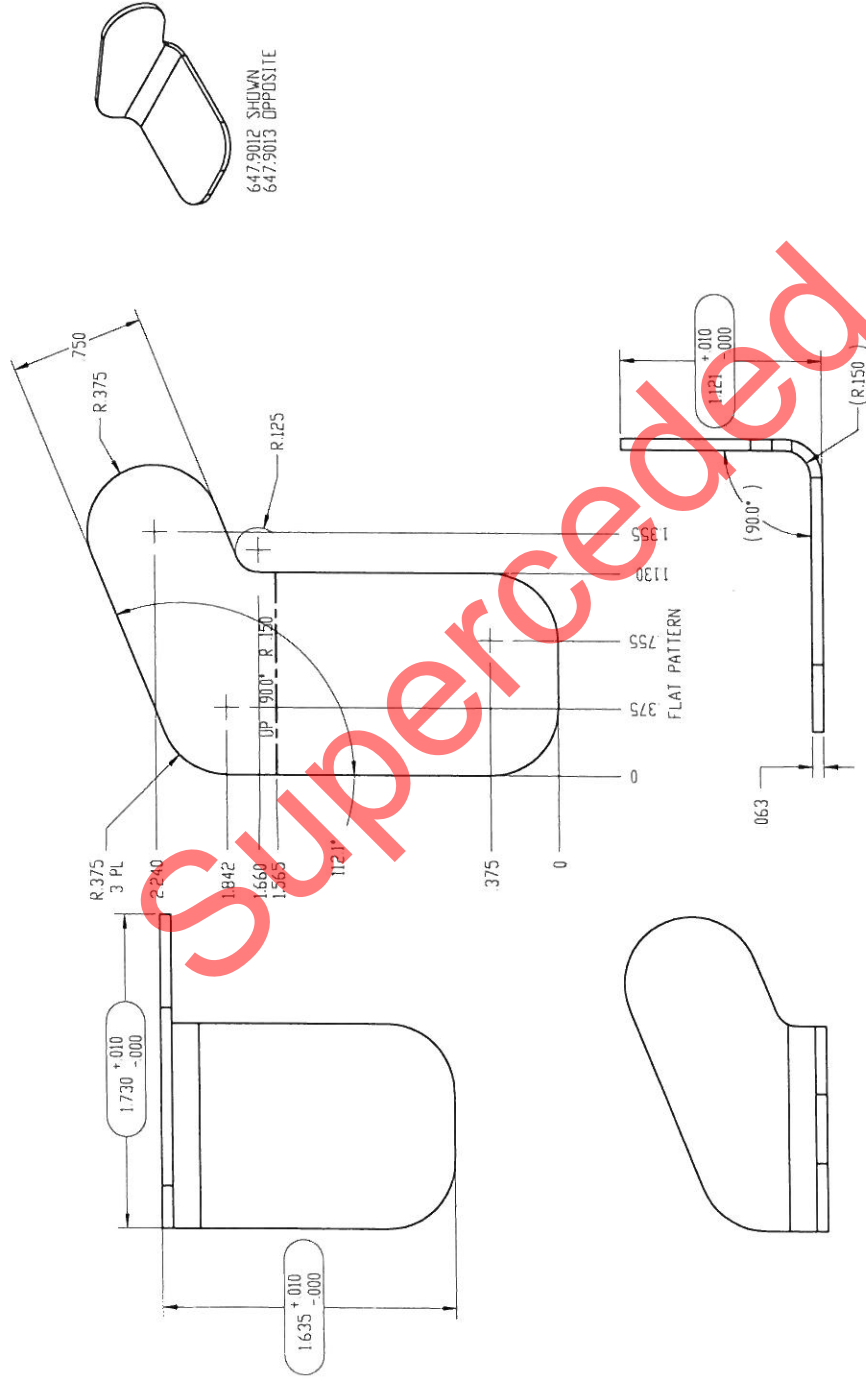
SHEET 1, NOTES:

NOTES: UNLESS OTHERWISE SPECIFIED

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N
- 3 DEBURR AND BREAK ALL SHARP EDGES
- 4 IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12PT. CENTURY GOTHIC.
- 5 ALL DIMENSIONS SHOWN PRIOR TO FINISH
- 6 PART DIMENSIONS CONTROLLED BY CAD MODEL; FILE NAME: 647.9016 DOUBLER.SLDPRJT-LAST MODIFIED 06-29-10
- 7 INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.
- 8 MATERIAL: 304SS IAW AMS 5643
- 9 FINISH: PRIME IAW MIL-P-23377J, TYPE I, CLASS N

5	R	647.9014	STRUT BRACKET		8		9	
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION		
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED			
				MDL	ICA	BOM	MAJOR	
				INSTALL	INSTRUC	MINOR	YES	
							NO	

**SHEET 3, IS:**

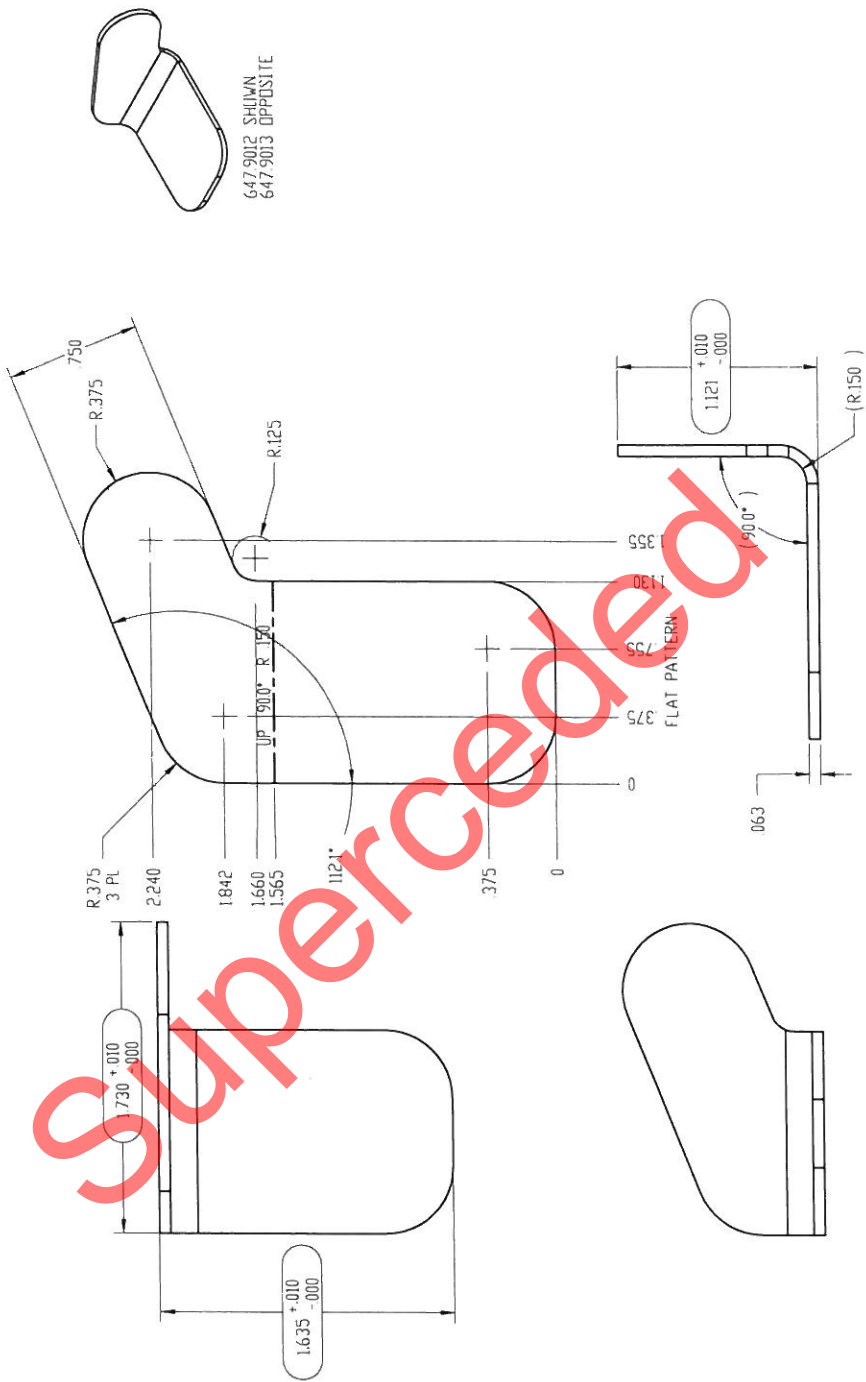


F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION



ENGINEERING CHANGE NOTICE		NO. 03213		SHEET 1 OF 1	
DWG NO. 647.9000		REV: N/C	PREPARED BY: A. QUAN	DATE: 11/09/11	
DWG TITLE: SHEETMETAL		MFG: <i>Daniel Baker</i>		EFF: <i>Maup Ly</i>	
APPROVED BY: <i>[Signature]</i>		ENGR: <i>[Signature]</i>		CURRENT ORDER AND STOCK	
REASON: REVISED 647.9013 DIMENSIONS					
TRANSACTION CODES (C): A-ADD C-CREATE R-REVISE D-DELETE					

**SHEET 3, IS:**



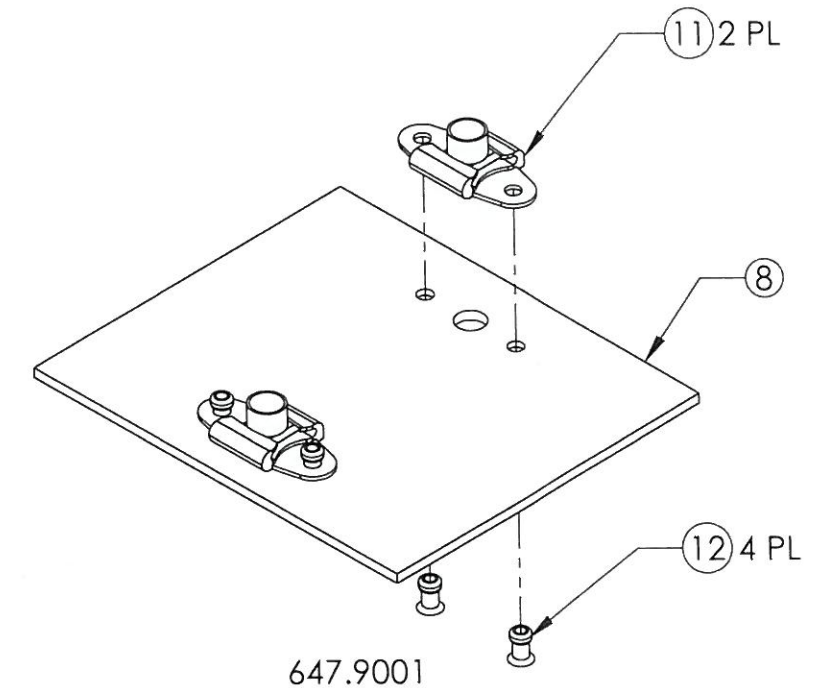
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:						
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL <input type="checkbox"/> INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO						
CHANGE CATEGORY DER REVIEW REQUIRED						

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE RELEASE: PR2		
N/C	INITIAL RELEASE	06-30-10	P. BRAVO

NOTES: UNLESS OTHERWISE SPECIFIED

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12PT. CENTURY GOTHIC.
5. ALL DIMENSIONS SHOWN PRIOR TO FINISH.
- 6 PART DIMENSIONS CONTROLLED BY CAD MODEL; FILE NAME: 647.9016 DOUBLER.SLDPRT-LAST MODIFIED 06-29-10
7. INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.



UNINCORPORATED ECN(s)

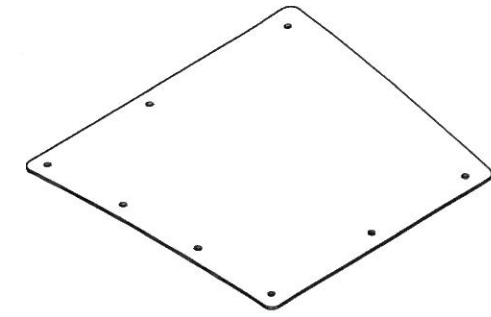
03213, 03246, 03707

	4	12	601.2277	RIVET	CCR264SS-3-02	
	2	11	601.1900	NUTPLATE	MS21059-3	
		10	647.9019	HINGE	1	2
		9	647.9018	DOUBLER	1	2
	1	8	647.9017	DOUBLER	1	2
		7	647.9016	DOUBLER	1	2 6
		6	647.9015	DOUBLER	1	2
		5	647.9014	STRUT BRACKET	1	2
		4	647.9013	FWD CLIP	1	2
		3	647.9012	FWD CLIP	1	2
		2	647.9011	DOUBLER	1	2
		1	647.9010	DOUBLER	1	2
			647.9001	DOUBLER ASSY	1	2
	.9001	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE (MO-DA-YR) 04-13-10	
647.8900		DRAWN BY R. ROSANO CHECKER P. BRAVO	
647.9400		DRAWING APPROVAL P. BRAVO 06-30-10	
		CONTRACT No.	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ±.5°	
		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
		SHEETMETAL	
		SIZE B	REV N/C
		CAGE CODE 07MZ6	DWG. NO. 647.9000
		SCALE NONE	SHEET 1 OF 9

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.9010 SHOWN  
647.9011 OPPOSITE

R.250 THRU  
4 PL

8.119  
7.715  
6.802  
6.480

8.419<sup>+.010</sup>  
-.000

7.010<sup>+.010</sup>  
-.000

DOWN 6.7° R 64.945

.400  
.250  
0  
Ø.160  
8 PL

0 .250 .385 .580 2.670 3.817 4.955 7.233 7.384 7.633

(R64.945)

7.625<sup>+.010</sup>  
-.000

FLAT PATTERN

.063

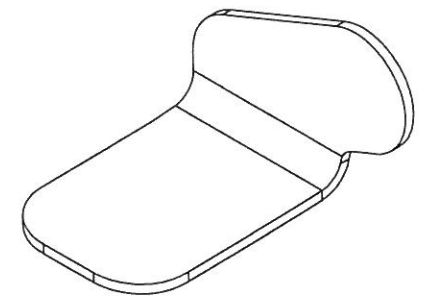
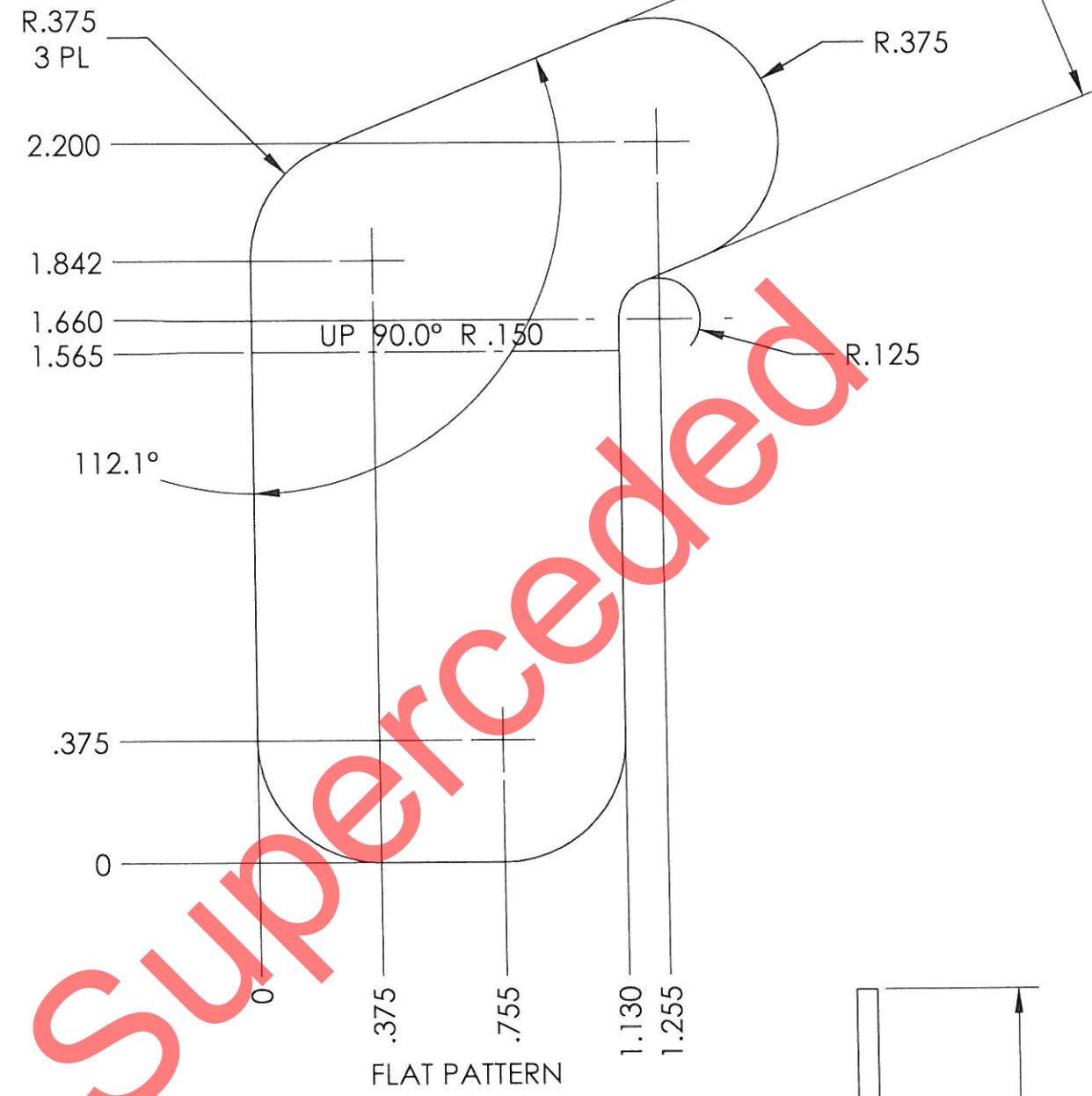
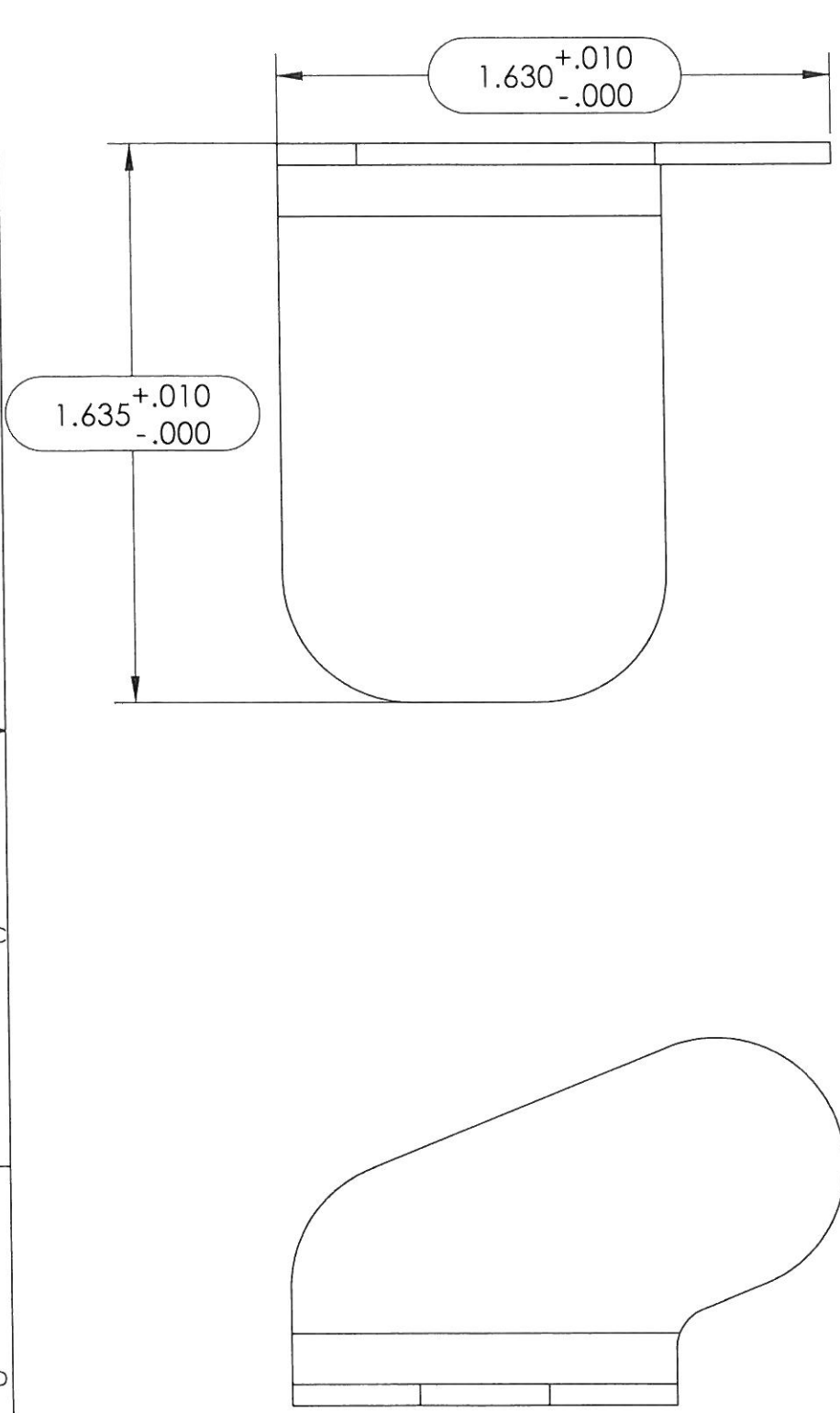
ORIGINAL DATE (MM-DD-YY) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 06-30-10 CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	REV N/C
CAGE CODE 07MZ6		DWG. NO. 647.9000	SCALE NONE
SHEET 2 OF 9			



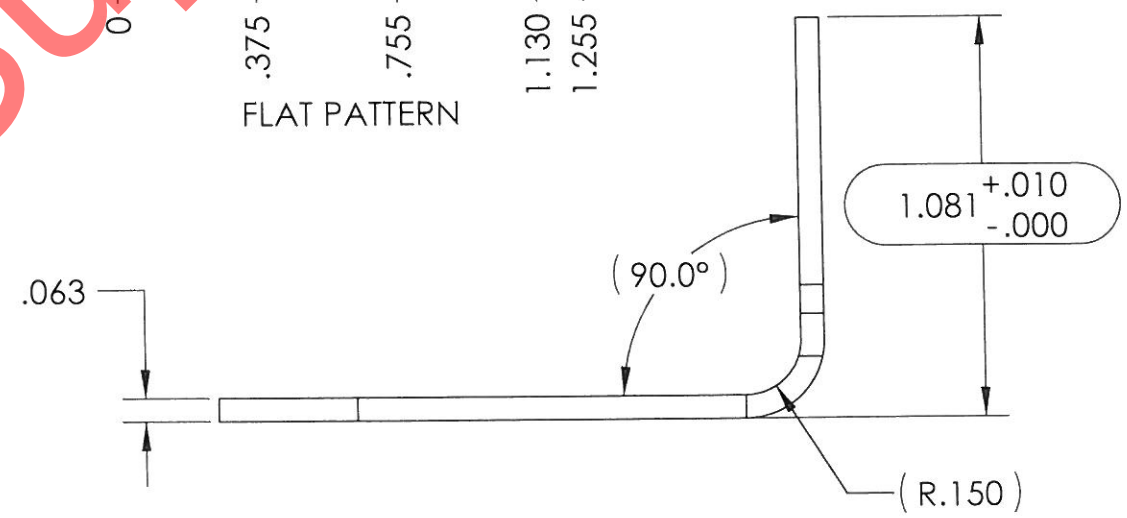
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

A  
B  
C  
D



647.9012 SHOWN  
647.9013 OPPOSITE



ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES	
DRAWN BY R. ROSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKER P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO			
04-30-10			
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	REV N/C
CAGE CODE 07MZ6		DWG. NO. 647.9000	
SCALE NONE		SHEET 3 OF 9	



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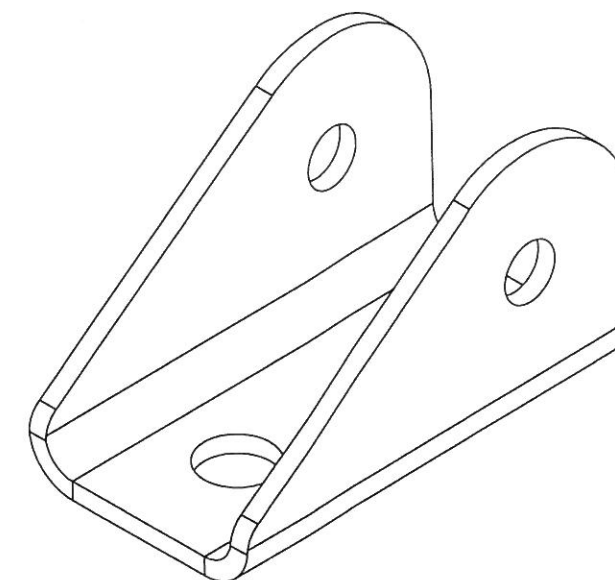
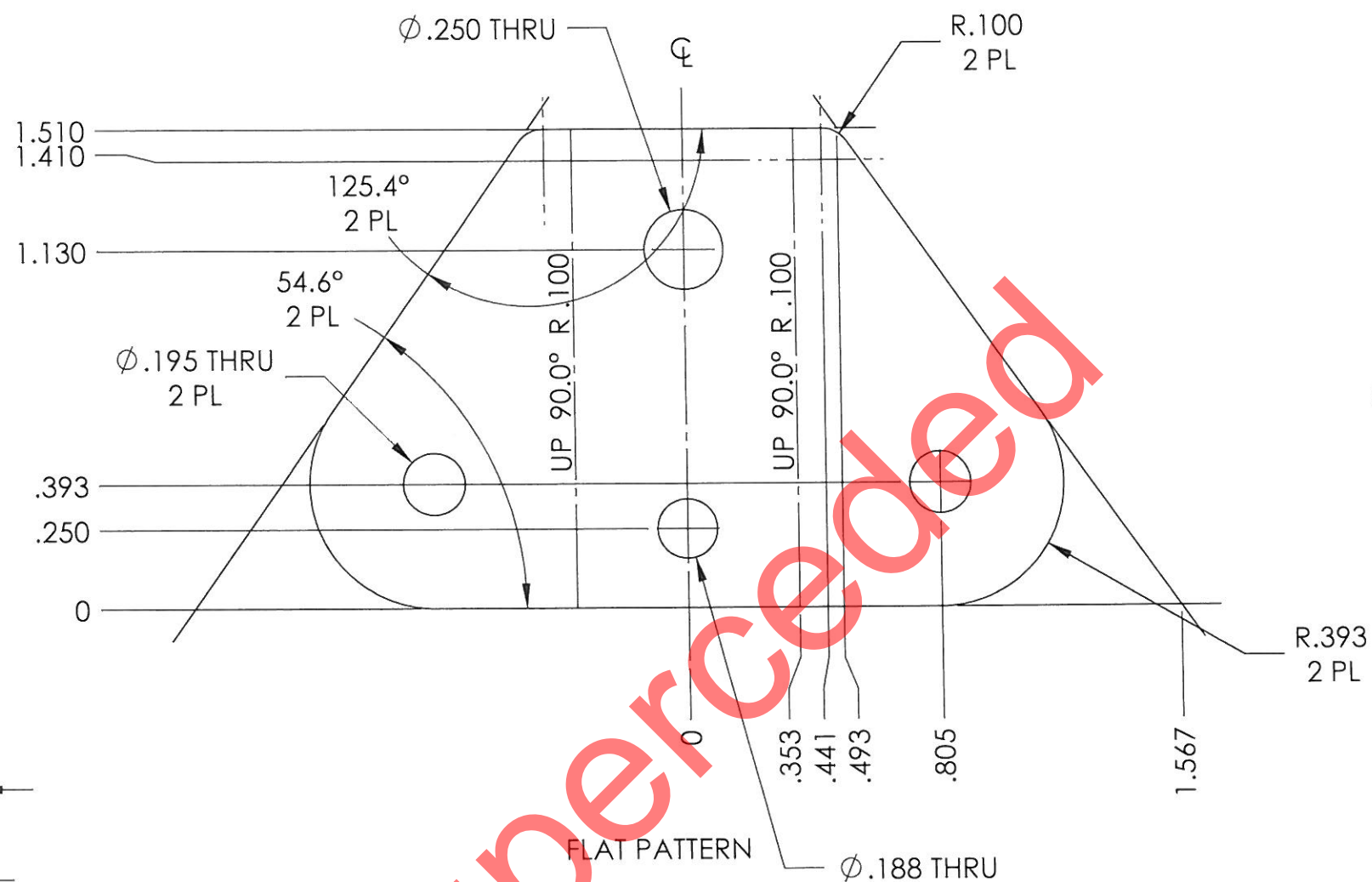
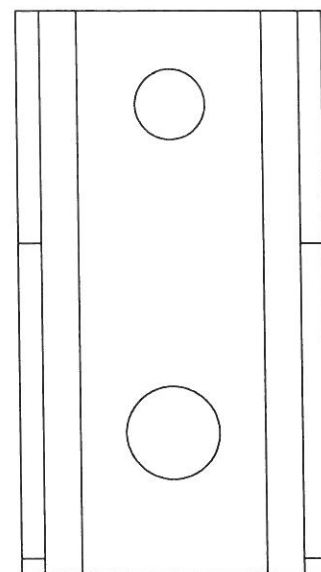
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

A

B

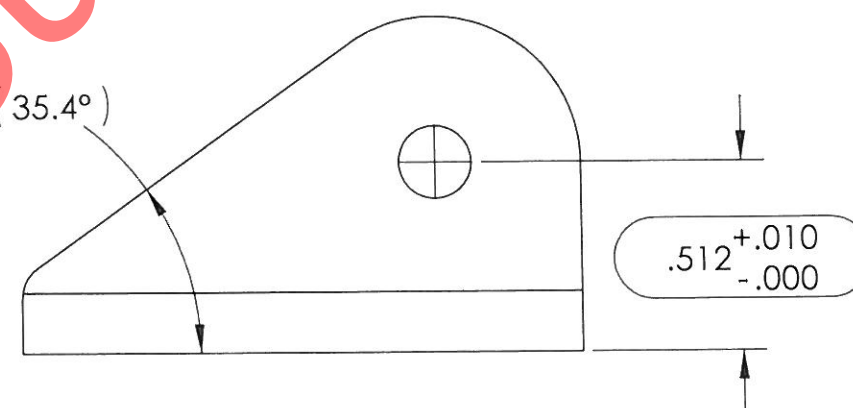
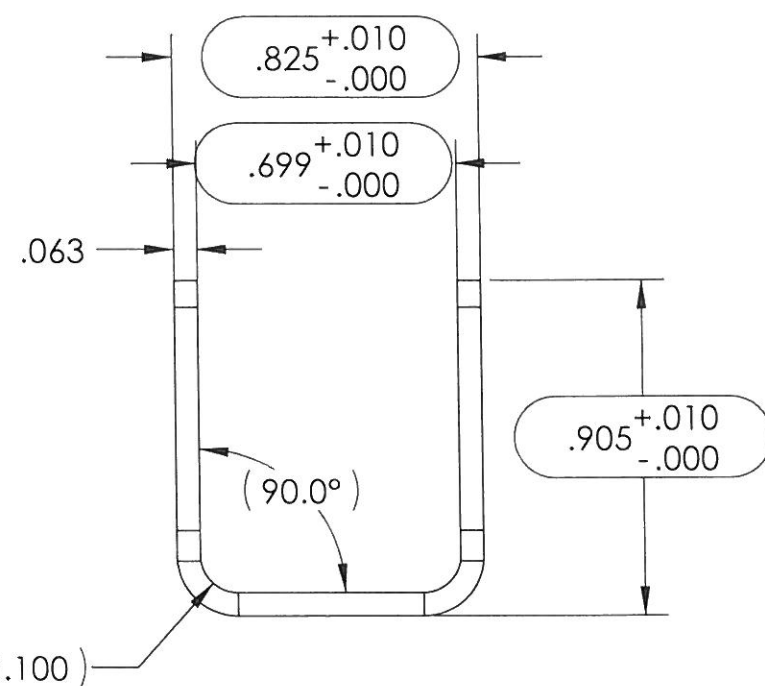
C

D



647.9014

R.393  
2 PL

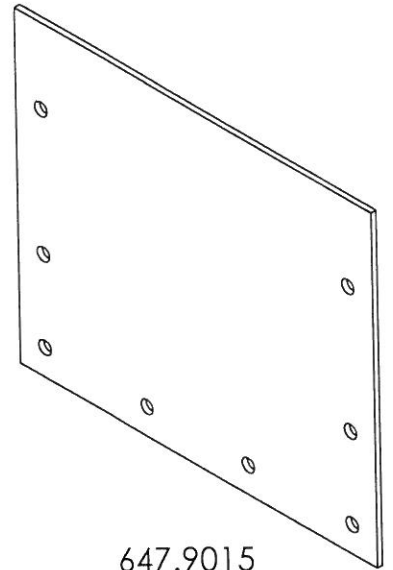
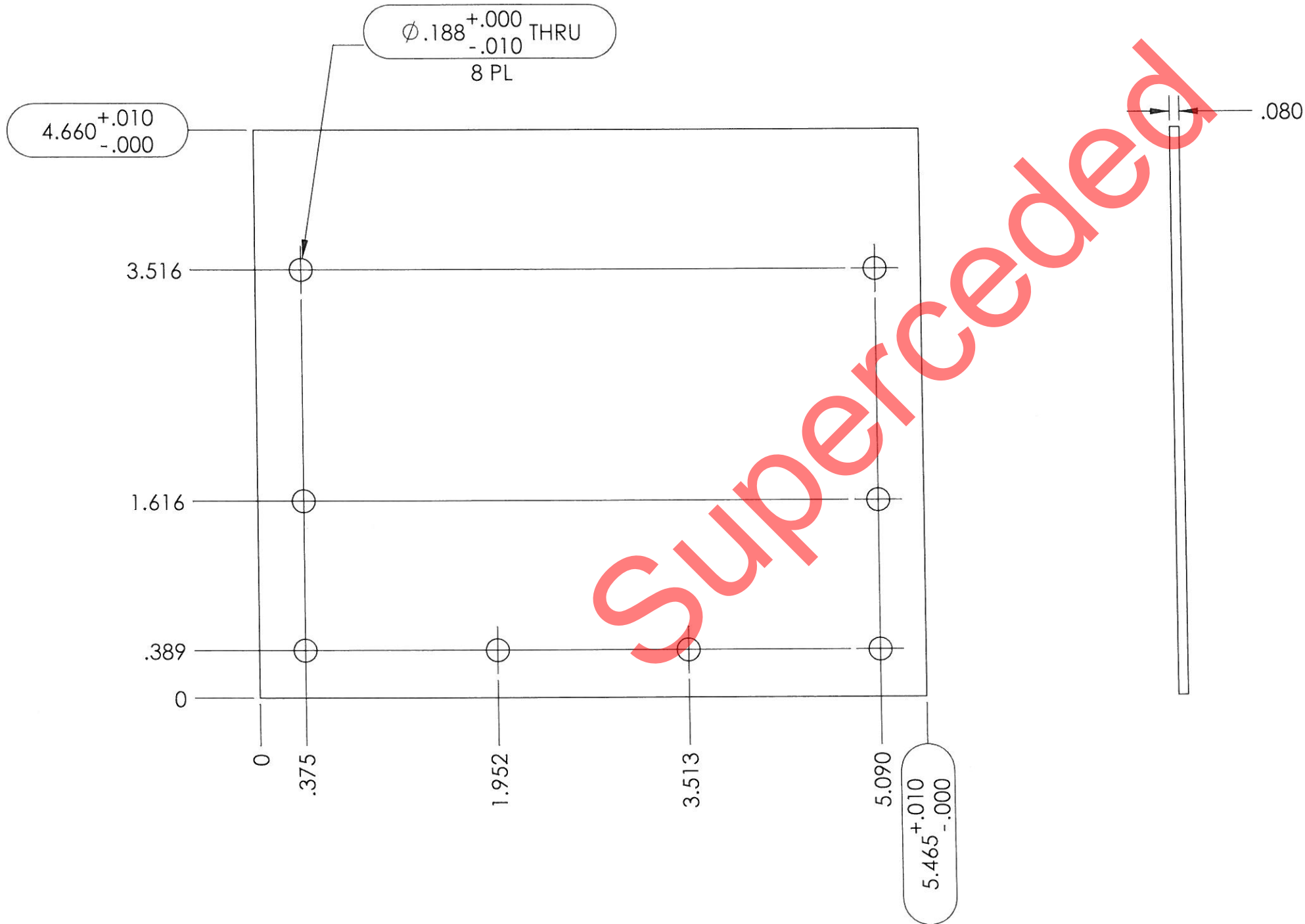


ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES	
DRAWN BY R. ROSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKER P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO		DWG. NO. 647.9000	
CONTRACT No.		REV N/C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	CAGE CODE 07M26
		SCALE NONE	SHEET 4 OF 9

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

A  
B  
C  
D

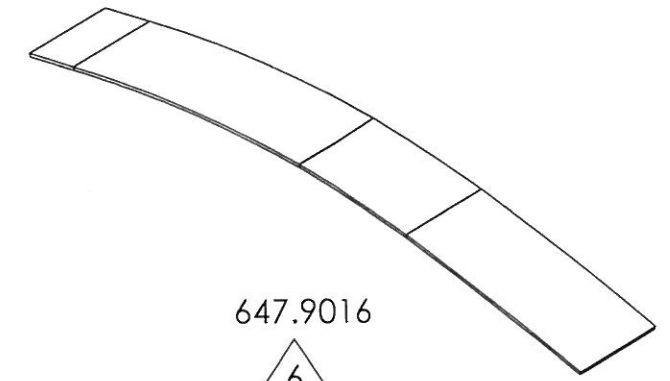
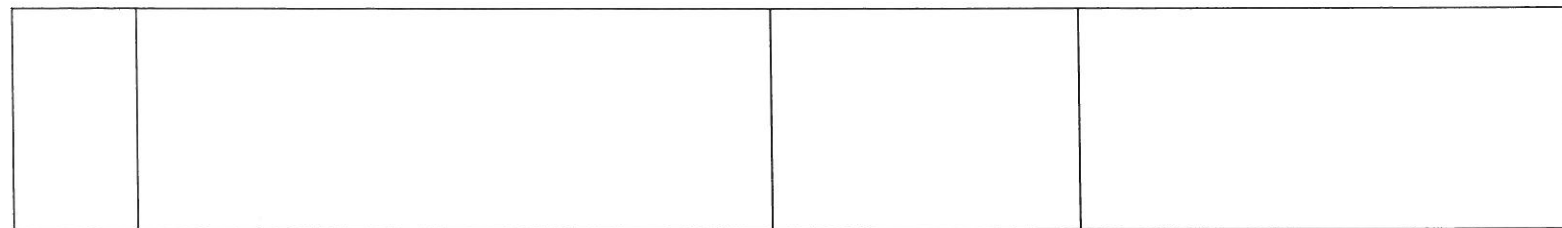


ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES	
DRAWN BY R. ROSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKER P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO 04-30-10		DWG. NO. 647.9000	
CONTRACT NO.		REV N/C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SCALE NONE	SHEET 5 OF 9

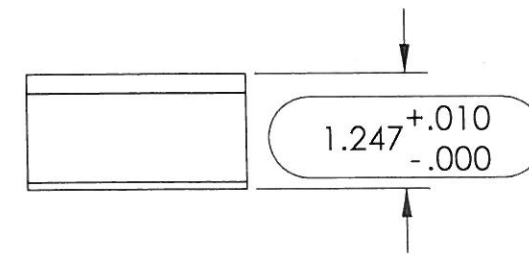
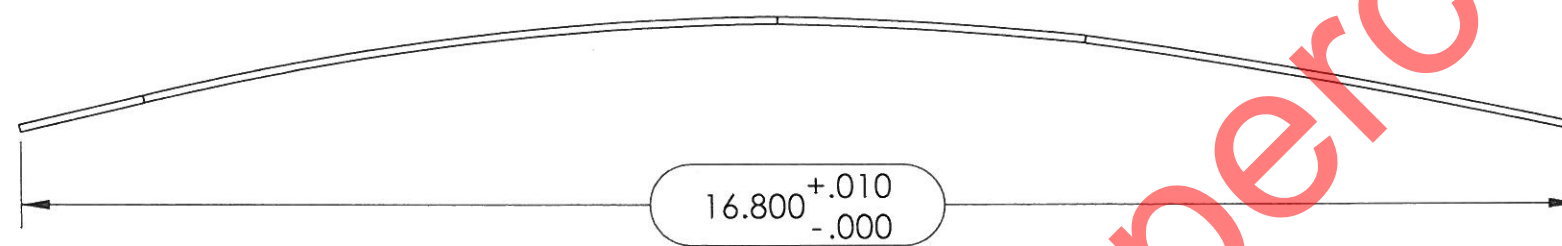
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

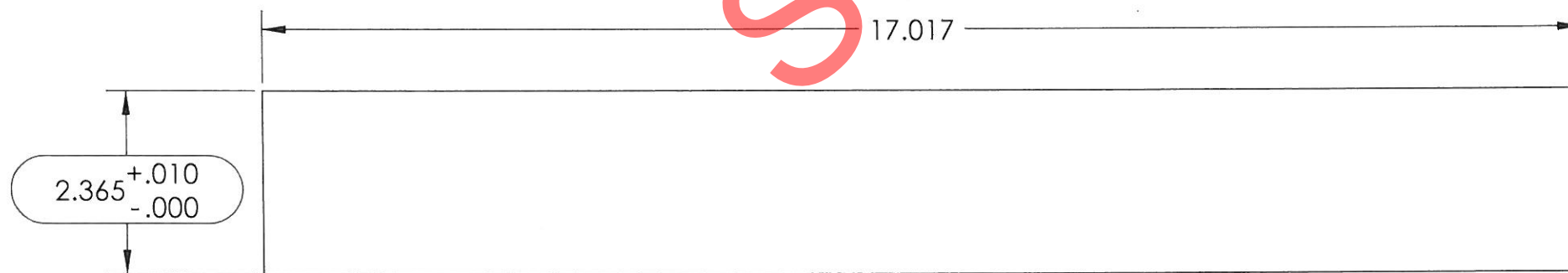
A



B



C



D

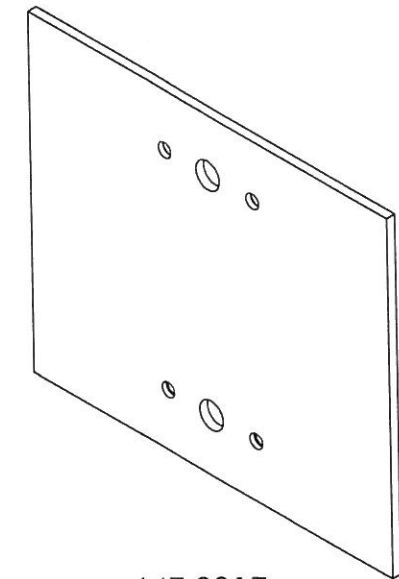
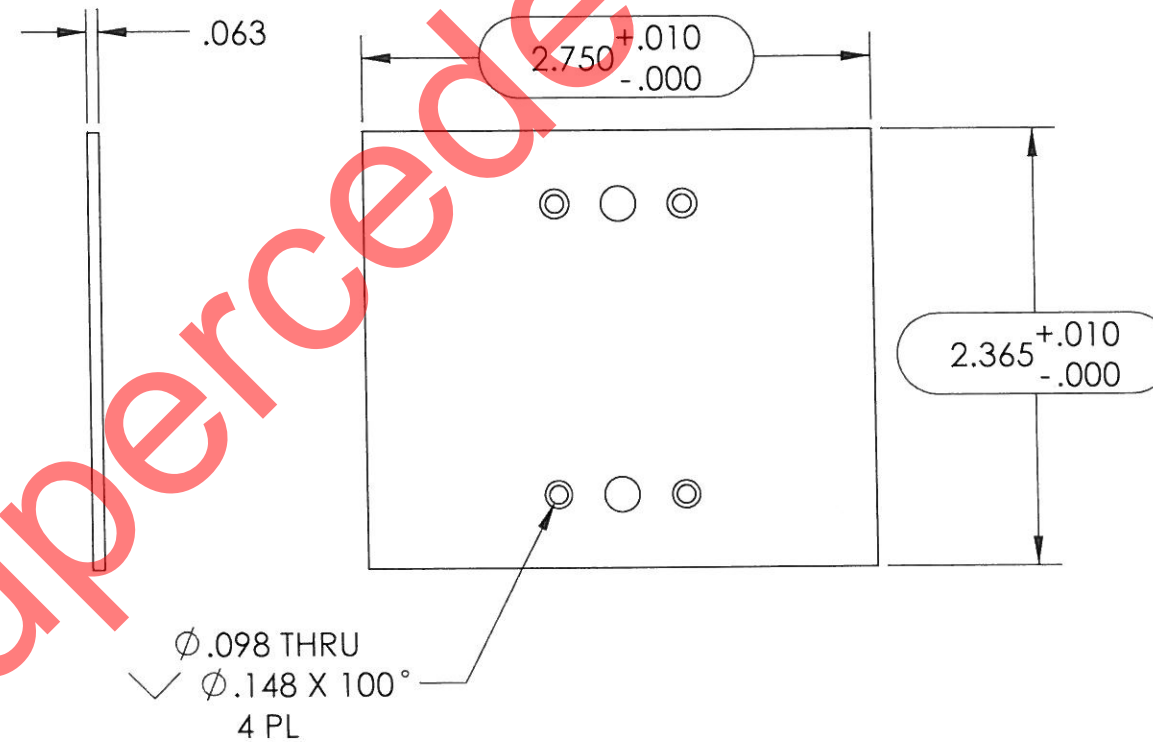
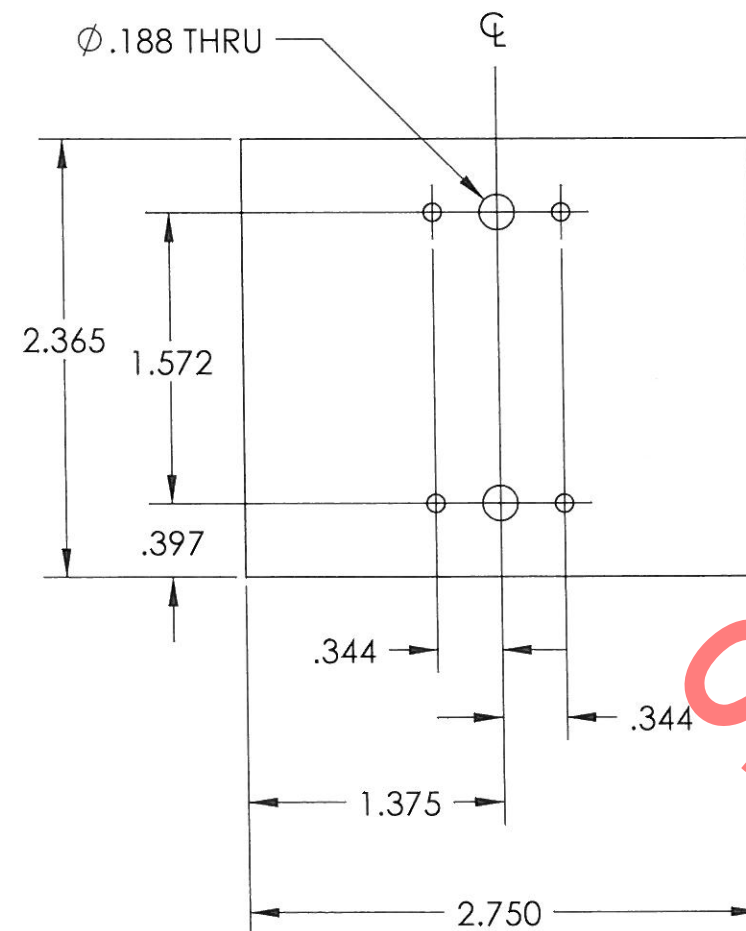
FLAT PATTERN

.080

ORIGINAL DATE (MO-DA-YR) 04-13-10		DRAWN BY R. ROSANO		CHECKER P. BRAVO	
DRAWING APPROVAL P. BRAVO		CONTRACT No.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	CAGE CODE 07MZ6	DWG. NO. 647.9000	REV. N/C
SCALE NONE				SHEET 6 OF 9	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



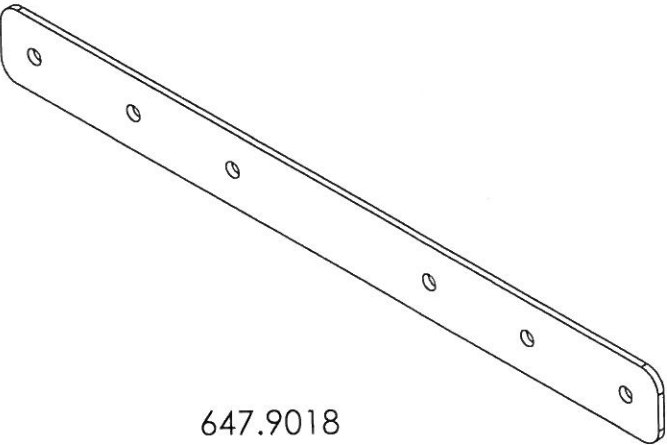
647.9017

ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 06-30-10 CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	REV N/C
SCALE NONE		DWG. NO. 07MZ6 647.9000	SHEET 7 OF 9

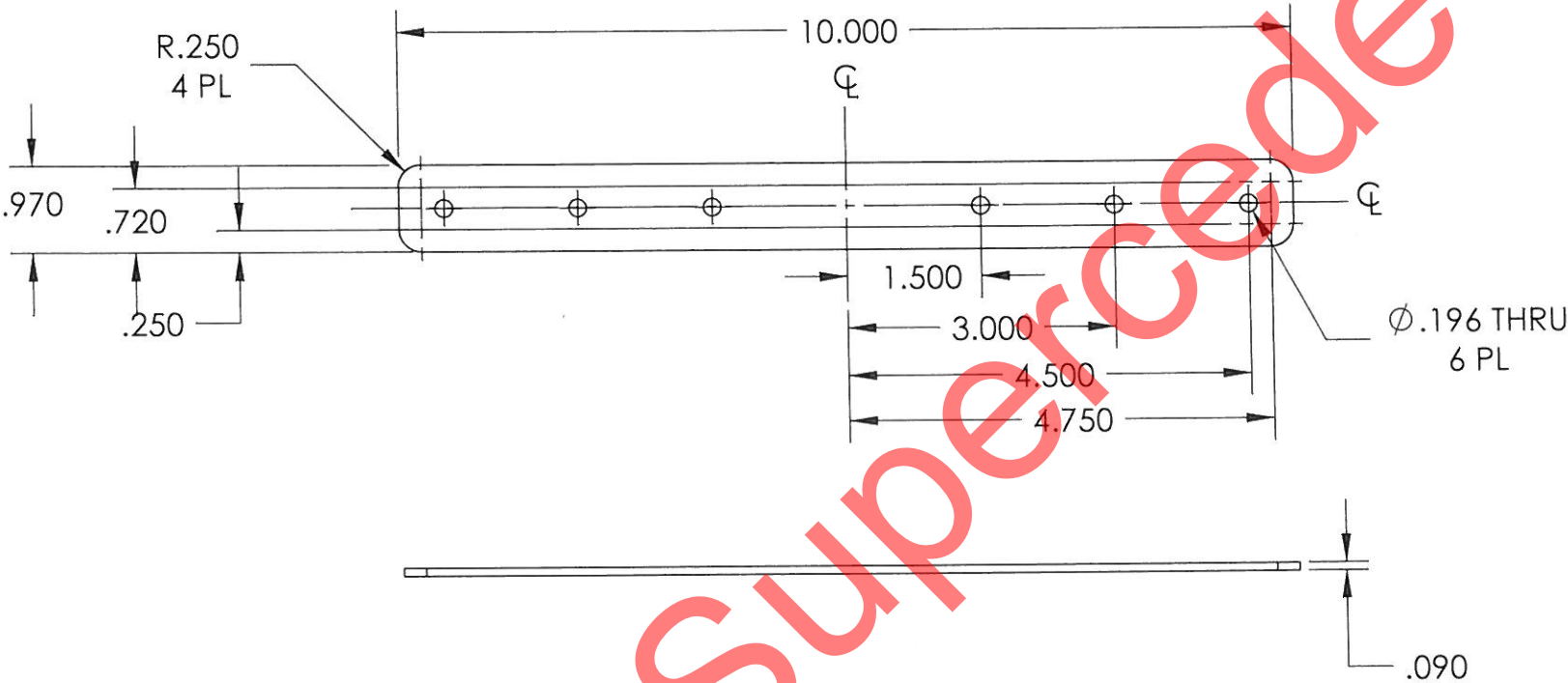


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.9018

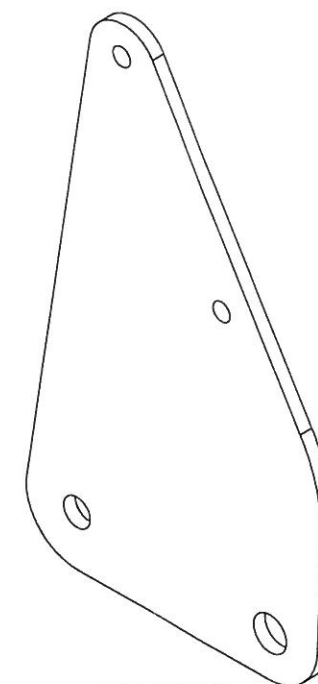
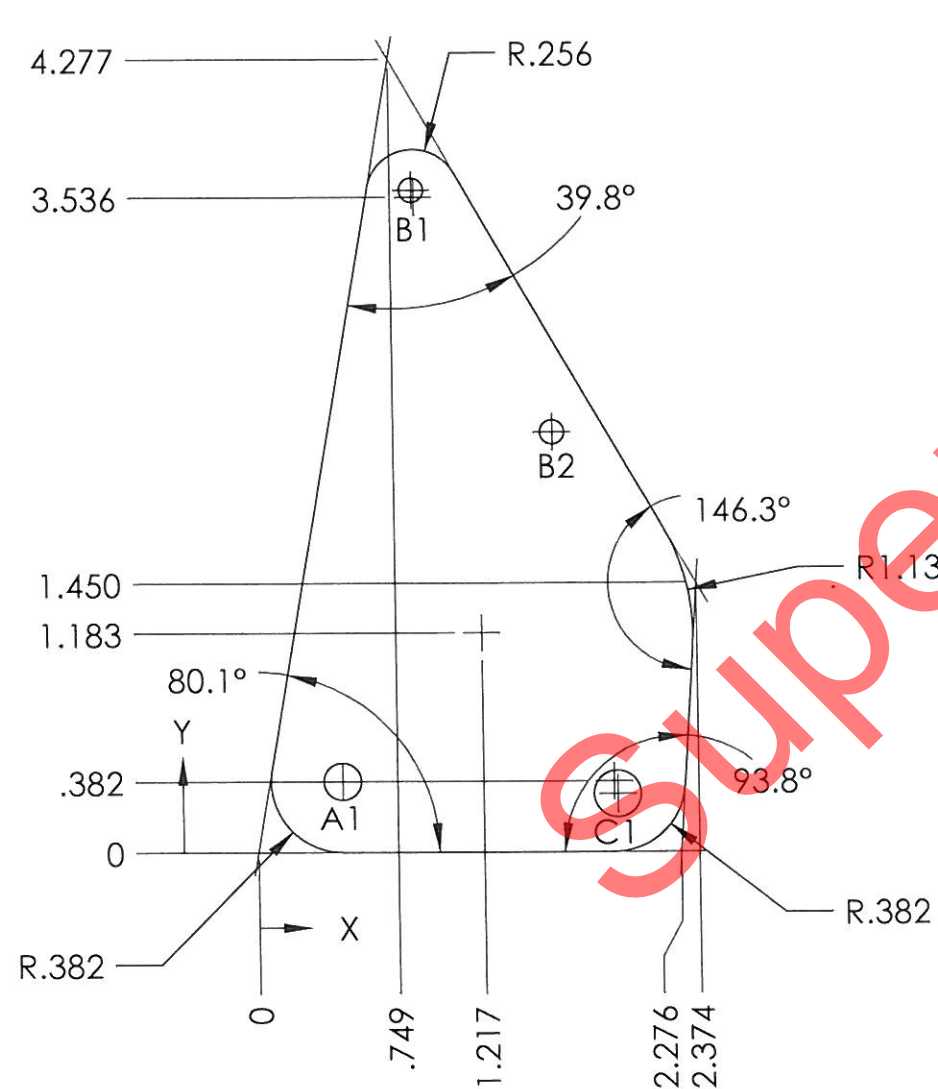


ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 06-30-10		SHEETMETAL	
CONTRACT No.		DWG. NO. 647.9000	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SIZE B	REV. N/C
SCALE NONE		SHEET 8 OF 9	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

PR2



647.9019

TAG	X LOC	Y LOC	SIZE
A1	.455	.382	Ø .201 THRU
B1	.867	3.573	Ø .130 THRU
B2	1.614	2.266	Ø .130 THRU
C1	1.939	.312	Ø .250 THRU

ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 04-30-10		SHEETMETAL	
CONTRACT NO.		SIZE B	REV N/C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07MZ6	DWG. NO. 647.9000
SCALE NONE		SHEET 9 OF 9	